

Work Order ID 138448

138448

Page 1

Tuesday, October 27, 2015 11:28:36 AM

Item ID: D350-689-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 10/20/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/30/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: OCT 29 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-689	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-017 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MLJ 15-11-09

2X

DAS
28
9-89

NOV 10 2015

2X

DAS
27
9-89

NOV 09 2015



2X

DAS
28
9-89

NOV 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 138448

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Page 2

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Item ID: D350-689-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shoulder Harness 4 Point Inertia Reel

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2X		DAS 28 9-89	NOV 10 2015
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-017 Location: FG029								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Sta 0151110

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER : ☐																																																																																																																															

Picklist Print

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Page 1

Work Order ID: 138448

138448

Parent Item: D350-689-017

D350-689-017

Parent Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 10/20/2015

Required Date: 10/30/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.04.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-4A		Purchased	No			110	Each	15.0000	2	4			
AN5-4A									**			BAS 27 9-89	DAS 6 9-89
Bolt													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST339			15					
					M128403			15					
D4071-041		Manufactured	No			110	Each	10.0000	2	4			
D4071-041									**			BAS 27 9-89	DAS 6 9-89
Shoulder Harness Assembly													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST465			10					
					133966			2					
					135530			4					
					136768			4					
MS21042L5		Purchased	No			110	Each	489.0000	2	4			
MS21042L5									**			BAS 27 9-89	DAS 6 9-89
Nut													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					GA			146					
					m127813			146					
					ST305			343					
					m127813			19					
					m131340			21					
					m132123			8					
					m132677			95					
					m133363			200					

NOV 09 2015

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

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Parent Item: D350-689-017

D350-689-017

Parent Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 10/20/2015

Required Date: 10/30/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

110

Each

279.0000

4

8

2

NAS1149D0516.J

Washer

DAS

27

9-89

Location

Loc Qty

Loc Code

ST269

279

M129022

8

M129706

271

DAS

28

9-89

NOV 09 2015

DAS
6
9-89

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DAS
28
9-89

6.0 PARTS LIST (OPTIONAL KITS)

Qty -015	Qty -017	Qty -031	Part Number	Description
X			D350-689-015	SEAT MODIFICATION KIT
	X		D350-689-017	SHOULDER HARNESS KIT
		X	D350-689-031	ARMREST KIT
		1	D2199-31	STRUT
2			D3029-1	SPRING
2			D3030-1	LOCK
1			D3033-1	SEAT TRACK
4			D3059-1	STUD
4			D3060-1	BUSHING
4			D3061-1	RADIUS BLOCK
	2		D4071-041	SHOULDER HARNESS ASSY
		1	D4671-1	ARMREST CUSHION
		1	D5159-041	SEAT BACK BRACE ASSY
		1	D5159-043	SEAT BACK BRACE ASSY
		1	D5159-045	SEAT RIB ASSY
		1	D5189-041	TUBE ASSY
		1	D5189-043	ARMREST ASSY
			AN3-12A	BOLT
		1	AN4-4A	BOLT
		1	AN4-6A	BOLT
		1	AN4-10A	BOLT
		2	AN4-14A	BOLT
		1	AN4-17A	BOLT
	2		AN5-4A	BOLT
		1	AN970-4	WASHER
		4	MS20600AD4W4	BLIND RIVET
		8	MS20600AD4W5	BLIND RIVET
		10	MS21042L3	NUT (OR MS21042-3)
		8	MS21042L4	NUT (OR MS21042-4)
4	2		MS21042L5	NUT (OR MS21042-5)
4			MS21059L3	NUTPLATE
1			MS24693-S273	SCREW
3			MS27039-1-10	SCREW
		1	MS27039-1-17	SCREW
		3	MS27039-1-18	SCREW
		4	MS27039-1-19	SCREW
		2	MS27039-1-20	SCREW
		4	MS27039-4-20	SCREW
		2	MS27039-4-22	SCREW
		4	MS27039-4-21	SCREW
		20	NAS1149D0332J	WASHER (OR AN960JD10L)
		17	NAS1149D0432J	WASHER (OR AN960JD416)
	4		NAS1149D0516J	WASHER (OR AN960JD516L)
4			NAS1149D0563J	WASHER (OR AN960JD516)
		2	NAS43DD4-16FC	SPACER